

# Work Order ID 53598

November 9, 2009 1:41:51 PM



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Item ID:	D2221	Accept		Setup	Start	
Revision ID:	H				Stop	
Item Name:	350 Basket Base					
Start Date:	09/11/2009	Start Qty:	1.00		Cust Item ID:	
Required Date:	20/11/2009	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	09/11/9	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr		* Converted to upgrade for DS19473						
D2221	Rev H								
100	Large Fab	0.00							
	Large Fab								
Large Fab	Memo	0.00							
	1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221 & DS1 9473 2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221 3- tack weld mesh on basket as per dwg D2221 A/R ER316 S.S. Rod Batch: M109213 1.5 Modify D3825-041 as per DS1 9473								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
	QC								
Quality Control	Memo	0.00							

PD 09.11.12  
Cpl 09 11 13

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Item ID: D2221	Accept		Setup	Start	
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Item Name: 350 Basket Base					
Start Date: 09/11/2009	Start Qty: 1.00		Cust Item ID:		
Required Date: 20/11/2009	Req'd Qty: 1.00		Customer:		

Reference:

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____

Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
QC	Memo	0.00				1			10/21/09
Quality Control									
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
	*pressure wash								
Powdercoat	Memo M112148	0.00							⇒ M Ogd 11/10
Powder Coating	1- Plug holes prior to								(X) /
	1ST COAT:								
	START TIME: 11:30am								
	OVEN TEMPERATURE: 400°F								
	FINISH TIME: 12:00pm								
	***** 2nd coat if necessary*****								
	2ND COAT:								
	START TIME: 12:30pm								
	OVEN TEMPERATURE: 400°F								
	FINISH TIME: 1:00pm								

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Item ID:	D2221	Accept		Setup	Start	
Revision ID:	H				Stop	
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Start Date:	09/11/2009	Start Qty:	1.00		Cust Item ID:	
Required Date:	20/11/2009	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00				X1			
150 	Identify as per dwg & Stock Location: _____	0.00							
Packaging Packaging	Memo	0.00							
160 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

MO 09/11/17

Regina

09/11/25  
M 09/11-25

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Work Order ID: 53598

Parent Item: D2221RevH

Parent Item Name: 350 Basket Base



Comments: ADD INDENTIFY AND STOCK DD 09.11.05 verified by:JLM

Start Date: 09/11/2009

Required Date: 20/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2221-1RevH		Manufactured	No			100	Each	18.0000	1.0000			
											SAD	09-11-19
Rib												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1	
48101	1	
Main Warehouse		
WA	17	
51872	5	
53213	12	

PD 09.11.10

D2221-5RevH

Manufactured No

100

Each

10.0000

2.0000



Rib



SAD 09-11-19

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	10	
53131	2	
53244	8	

PD 09.11.10

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Work Order ID: 53598



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 09/11/2009

Required Date: 20/11/2009

Comments: ADD INDENTIFY AND STOCK DD 09.11.05 verified by:JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2221-7RevH

Manufactured

No

100

Each

5.0000

1.0000



SAD 09-11-19

Rib

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

5

51251

1

53246

4

PD 09.11.10

D2232-3RevC

Manufactured

No

100

Each

19.0000

2.0000



SAD 09-11-19

Basket Hinge

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

4

50024

2

51870

2

Main Warehouse

WA

15

53344

15

PD 09.11.11

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Work Order ID: 53598



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 09/11/2009

Required Date: 20/11/2009

Comments: ADD INDENTIFY AND STOCK DD 09.11.05 verified by:JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2235-1RevB1  Basket Rib		Manufactured	No			100	Each	16.0000	2.0000			



SAD 09-11-19

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
ST	10	
53215	10	
Main Warehouse		
WA	6	
50565	3	
51871	3	

① PD 09.11.10

① PD 09.11.10

D2581RevA1

Manufactured No

100

Each

48.0000

2.0000



Mounting Bracket



SAD 09-11-19

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
ST	12	
46086	2	
48428	1	
51120	9	
Main Warehouse		
WA	36	
50872	1	
51745	35	

① PD 09.11.12

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Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 09/11/2009

Required Date: 20/11/2009

Comments: ADD INDENTIFY AND STOCK DD 09.11.05 verified by:JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3442-1RevA		Manufactured	No			100	Each	10.0000	2.0000			
Shim												

SAD 09-11-19

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST

1

46767

1

Main Warehouse

WA

9

50951

9

PD 09.11.11

D3825-041RevA

Manufactured

No

100

Each

6.0000

2.0000



Rib Assembly (Basket End)

SAD 09-11-19

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

WA

6

53381

6

PD 09.11.10

D3826-041RevB

Manufactured

No

100

Each

6.0000

2.0000



Rib / Gusset Assembly

SAD 09-11-19

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

WA

6

53216

6

PD 09.11.10

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Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 09/11/2009

Required Date: 20/11/2009

Comments: ADD INDENTIFY AND STOCK DD 09.11.05 verified by:JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3827-041RevA      Manufactured      No

100

Each

6.0000

1.0000



SAD 09-11-19

Rib Assembly (Inboard)

Warehouse      Loc Qty      Loc Code

Location

Main Warehouse

ST

6

51339

1

53247

5

PD 09.11.10

D3832-1RevA      Manufactured      No

100

Each

5.0000

1.0000



SAD 09-11-19

Mesh (Base)

Warehouse      Loc Qty      Loc Code

Location

Main Warehouse

ST

2

46306

1

46774

1

Main Warehouse

WA

3

53218

3

PD 09.11.12

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Work Order ID: 53598



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base



Start Date: 09/11/2009

Required Date: 20/11/2009

Comments: ADD IDENTIFY AND STOCK DD 09.11.05 verified by:JLM

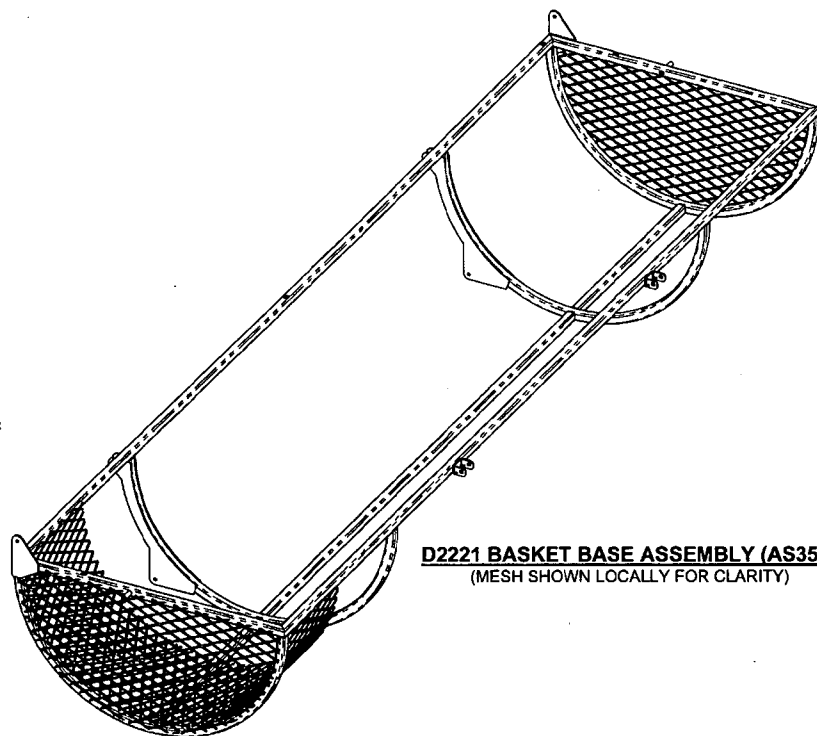
Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3833-1RevA		Manufactured	No			100	Each	8.0000	2.0000			
										SAD	09-11-09	
Mesh (Base End Face)												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
WA	8	
50025	2	
53214	6	

PD 09.11.12



**D2221 BASKET BASE ASSEMBLY (AS350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 53595  
09-11-9

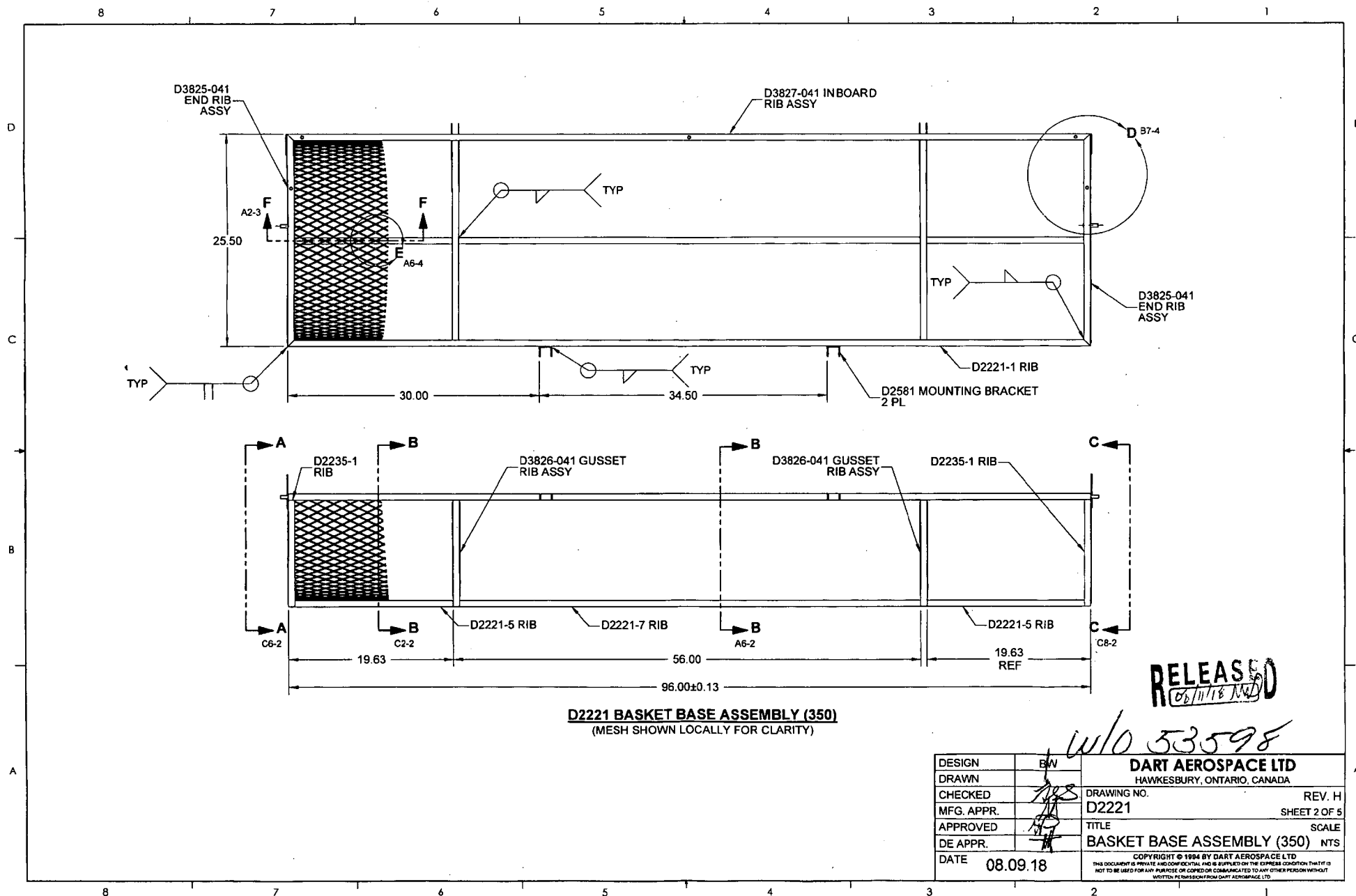
**NOTES:**

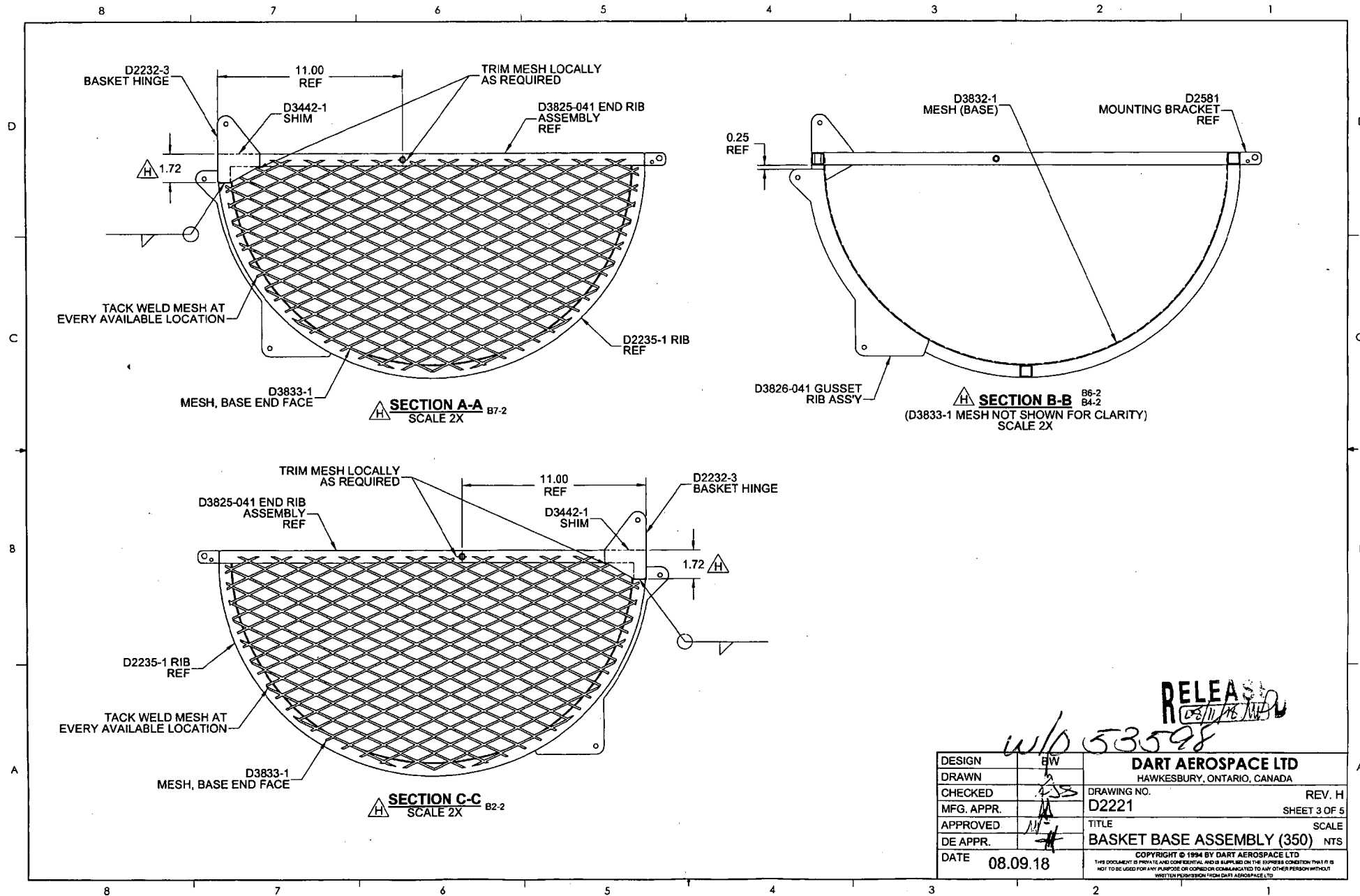
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

RELEASED  
08/11/95

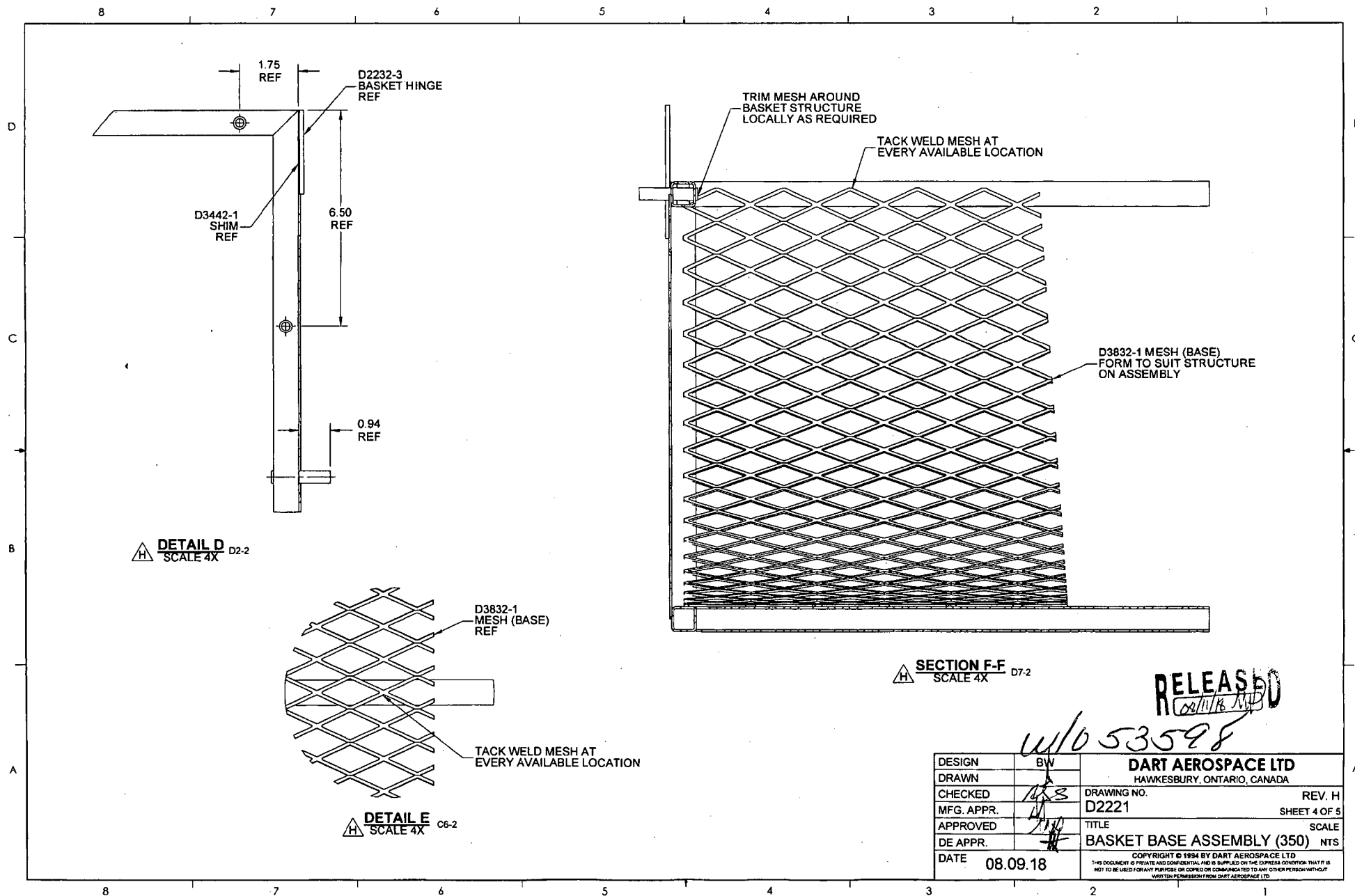
H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C5-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/-5/-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JS		
CHECKED	JS	DRAWING NO.	REV. H
MFG. APPR.	JS	D2221	SHEET 1 OF 5
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

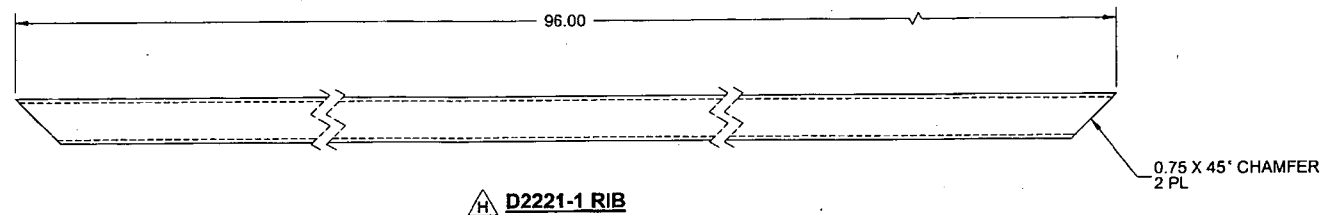
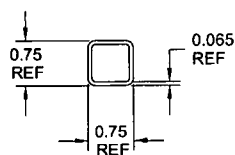




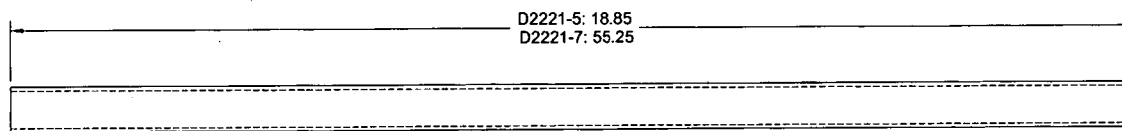
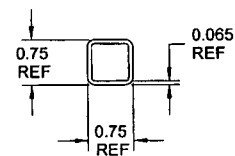
RELEASED  
03/11/16

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	2	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CS	DRAWING NO.	REV. H
MFG. APPR.	A	D2221	SHEET 3 OF 5
APPROVED	M	TITLE	SCALE
DE APPR.	#	<b>BASKET BASE ASSEMBLY (350) NTS</b>	
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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**D2221-1 RIB**



**D2221-5/-7 RIB**

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

**RELEASED**  
08/10/18

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. H
MFG. APPR.	MS	D2221	SHEET 5 OF 5
APPROVED	MS	TITLE	SCALE
DE APPR.	MS	<b>BASKET BASE ASSEMBLY (350)</b> NTS	
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

